

4/06

u. 25

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	20296
<b>Description:</b> Mounting Lug/Nut Plate Kit	<b>Part Number:</b>	K10017
<b>Dwg:</b> D3175 Rev. A; D3178 Rev. A	<b>Qty:</b>	64
		Page 1 of 2

2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <b>Note: K10017 Kits to be made in multiples of 4. (1) K10017 Kit consists of (2) D3175-041 and (2) D3178-041.</b>	HJ	04.01.26	64
2	MV	Cut blanks: 3.00" x 1.520" Material: 5052-H32/H34 sheet (QQ-A-250/8) 0.063" thick (M5052H32S.063) <b>(Cut 1 stack of 8 per (4) K10017)</b> <b>Identify as D3178-1</b> Batch: M12524	SL	04/02/07	8
3	MV	Cut blanks: 2.5" x 1.5" x 2.2" (grain along 2.2") Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) (M6061T6B1.500x02.500) <b>(Cut 16 blanks per (4) K10017)</b> <b>Identify as D3175-1</b> Batch: M10974 <b>(Note: (2) D3175-1 are required per D3175-041 assembly)</b>	SL	04/02/07	16
4	MV	Cut blanks: 2.125" x 1.250" Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) 0.375" thick (M6061T6B0.375x01.250) <b>(Cut 8 blanks per (4) K10017)</b> <b>Identify as D3175-3</b> Batch: M7321	MZ	04/02/07	8
5	MV	Machine D3178-1 as per Folio FA296 and Dwg D3178	SL	04/02/07	8
6	QC2	Inspect parts as they come off the CNC machine	SL	04/02/07	8
7	QC8	Second inspection	SL	04/02/07	8
8	MV	Machine D3175-1 as per Folio FA293 and Dwg D3175	SL	04/02/08	8 x 2
9	QC2	Inspect parts as they come off the CNC machine	SL	04/02/08	8 x 2
10	MV	Deburr and Tumble	SL	04/02/08	8 x 2
11	QC8	Second inspection	SL	04/02/08	8 x 2
12	MV	Machine D3175-3 as per Folio FA294 and Dwg D3175	SL	04/02/08	8
13	QC2	Inspect parts as they come off the CNC machine	SL	04/02/08	8
14	MV	Deburr and Tumble	SL	04/02/08	8
15	QC8	Second inspection	SL	04/02/08	8
16	GA	C'sink D3178-1 holes as per Dwg D3178	SB	04/02/10	8
17	GA	Deburr stack of D3178-1	SB	04/02/10	8
18	QC5	Inspect C'sink	SB	04.02.10	8
19	FP	Chemical Conversion Coat D3178-1, D3175-1 & D3175-3 per QSI 005 4.1	SB	04/02/10	8

BB 04-213

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE					
DATE	STEP	Description of NC section A	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
04-02-12	1320202 N/A	Not enough D3173-1 beams were made. Here were supposed to be 4 and there are only 3.	Initial [Signature]	assemble the 3 beams store extra 2 D3175-011 and 2 D3175-011 in K10017 kit in stores [Signature] 04-02-12	[Signature] 04-02-12	N/A	[Signature] 04-02-12

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	20296
<b>Description:</b> Mounting Lug/Nut Plate Kit	<b>Part Number:</b>	K10017
<b>Dwg:</b> D3175 Rev. A; D3178 Rev. A	<b>Qty:</b>	<del>2</del>
		Page 2 of 2

Step	Location	Procedure	By	Date	Qty																
20	QC3	Inspect Conversion Coat	AB	04.02.10	8																
21	GA	Assemble D3178-041 as per Dwg D3178 <b>Pick:</b> <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>16</td><td>MS20426AD3-4</td><td>Rivet</td><td>M 9748</td></tr><tr><td>8</td><td>MS21059L3</td><td>Nut Plate</td><td>M 12240</td></tr></table> <b>Identify as D3178-041</b>	Qty	Part Number	Description	Batch	16	MS20426AD3-4	Rivet	M 9748	8	MS21059L3	Nut Plate	M 12240	SB	04/02/10	8				
Qty	Part Number	Description	Batch																		
16	MS20426AD3-4	Rivet	M 9748																		
8	MS21059L3	Nut Plate	M 12240																		
22	QC5	Inspect D3178-041 Assembly	AB	04.02.10	8																
23	GA	Assemble D3175-041 as per Dwg D3175 <b>Pick:</b> <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>4</td><td>AN3-7A</td><td>Bolt</td><td>M 5288</td></tr><tr><td>8</td><td>AN960JD10L</td><td>Washer</td><td>M 13441</td></tr><tr><td>4</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M 14019</td></tr></table> <b>Identify as D3175-041</b>	Qty	Part Number	Description	Batch	4	AN3-7A	Bolt	M 5288	8	AN960JD10L	Washer	M 13441	4	MS21042L3	Nut (or -3)	M 14019	SB	04/02/10	8
Qty	Part Number	Description	Batch																		
4	AN3-7A	Bolt	M 5288																		
8	AN960JD10L	Washer	M 13441																		
4	MS21042L3	Nut (or -3)	M 14019																		
24	QC5	Inspect D3175-041 Assembly	AB	04.02.10	8																
25	FP	Powder Coat <b>D3175-041 Only</b> Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	MM	04.02.10	8																
26	QC3	Inspect Powder Coat	AB	04.02.10	8																
27	PK	<b>Identify and Stock as K10017.</b> <b>Note: (1) Kit consists of (2) D3175-041 and (2) D3178-041.</b> <table><tr><td>Part Number</td><td>Description</td><td>Qty</td></tr><tr><td>D3175-041</td><td>Mounting Lug</td><td>8</td></tr><tr><td>D3178-041</td><td>Nut Plate</td><td>4</td></tr></table>	Part Number	Description	Qty	D3175-041	Mounting Lug	8	D3178-041	Nut Plate	4	AB	04.02.10	4							
Part Number	Description	Qty																			
D3175-041	Mounting Lug	8																			
D3178-041	Nut Plate	4																			
28	AC	Parts to stock and Prorate cost to parts per Step 27. Cost / part 76.14	SG	04.02.12	4																
29	DC	Close W/O 76.14 Inspect Level 21	KJ	04.02.17	4																

Rev	Date	Change	Revised By	Approved
A	03.01.28	New issue	KJ/RF	
B	03.02.28	Modify Step 1,2,3,4,21,23	KJ/RF	

**RELEASED**  
03.02.04

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

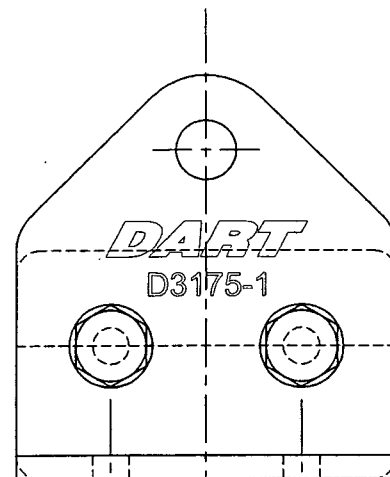
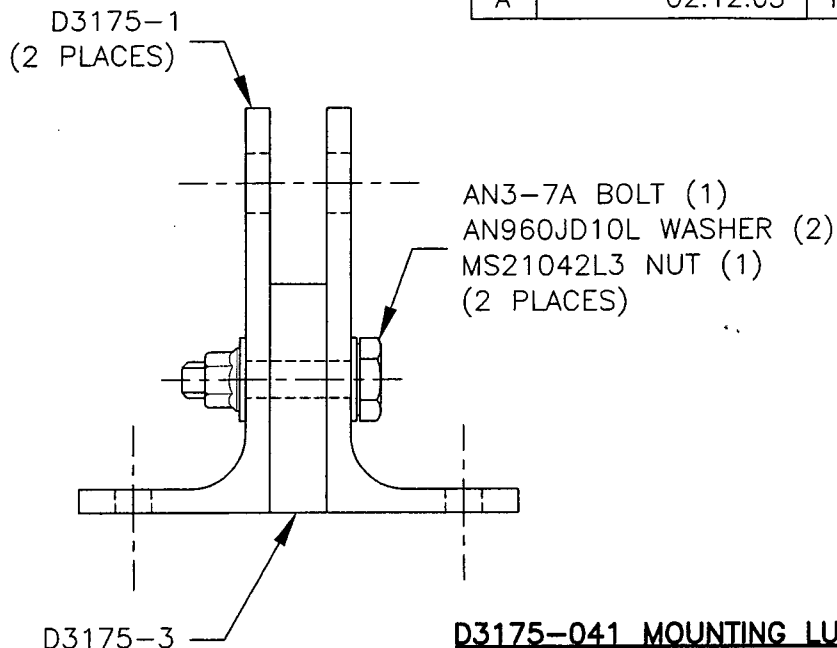
PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**NOTE:** Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3175	REV. A SHEET 1 OF 2
DATE 02.12.03		TITLE MOUNTING LUG	SCALE 1:1
A	02.12.03	NEW ISSUE	

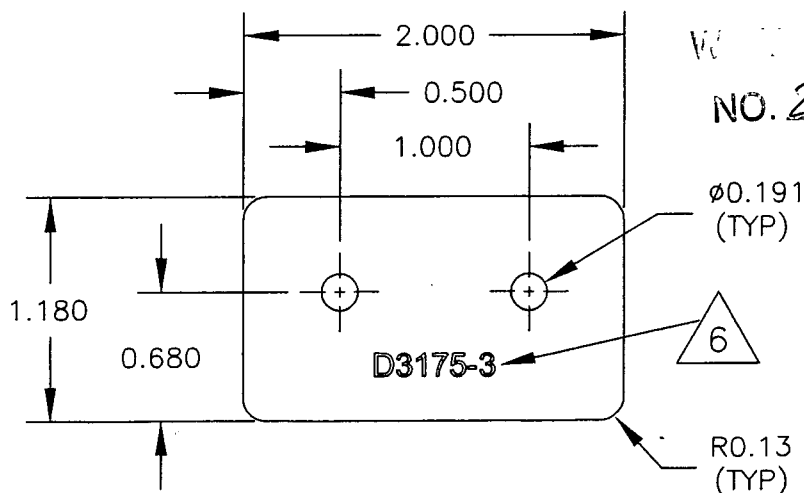


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RELEASED  
02.12.03 *#*

**D3175-041 MOUNTING LUG**  
FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1)  
PER DART QSI 005 4.3



**D3175-3 SPACER**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.285 TO 0.290 THICK  
(QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

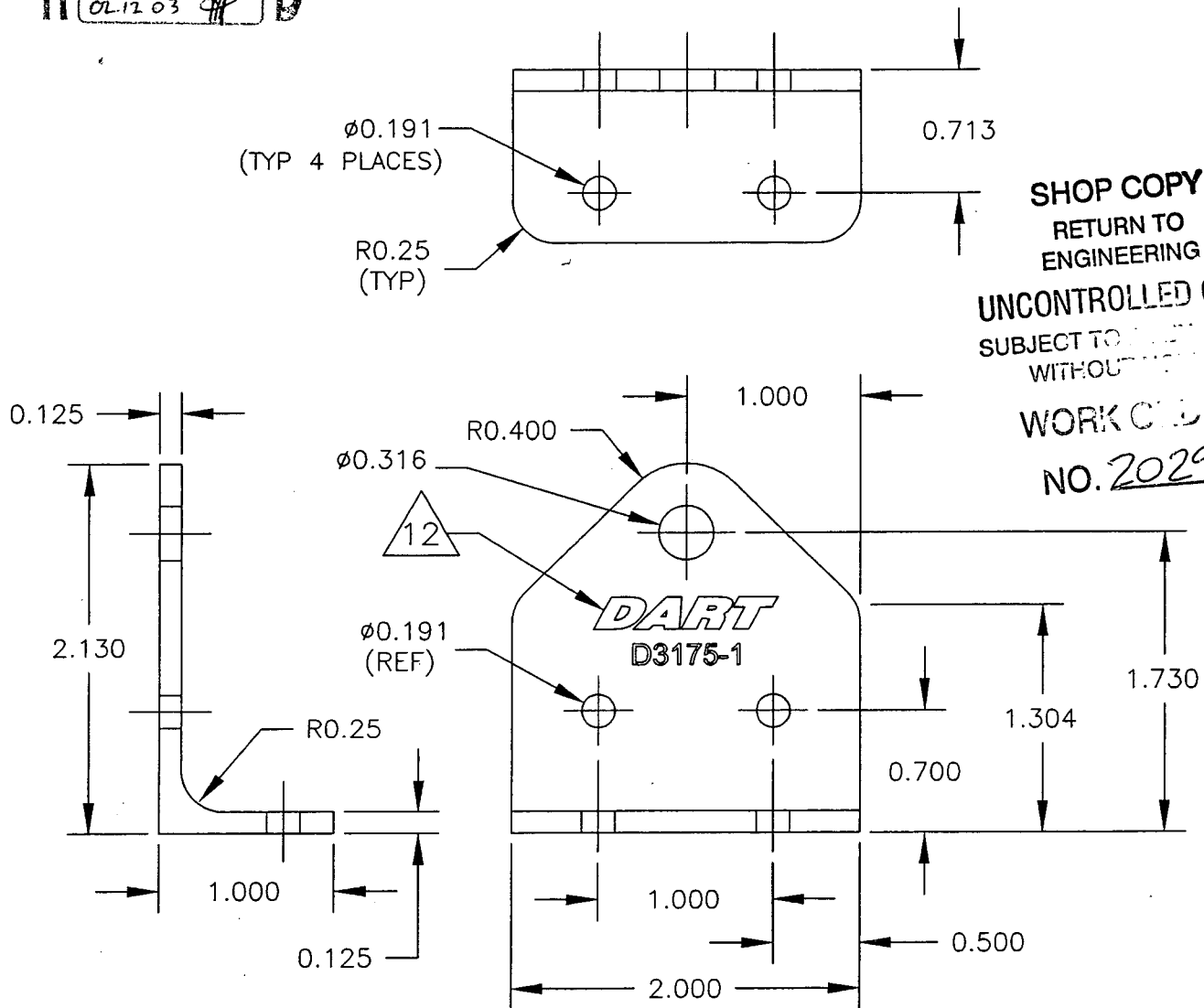
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3175	REV. A SHEET 2 OF 2
DATE 02.12.03	TITLE MOUNTING LUG		SCALE 1:1

RELEASED  
02.12.03 [Signature]



#### D3175-1 BRACKET

7) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)

8) BREAK ALL SHARP EDGES 0.005 TO 0.015

9) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

11) ALL DIMENSIONS ARE IN INCHES

12) ENGRAVE DART LOGO & P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

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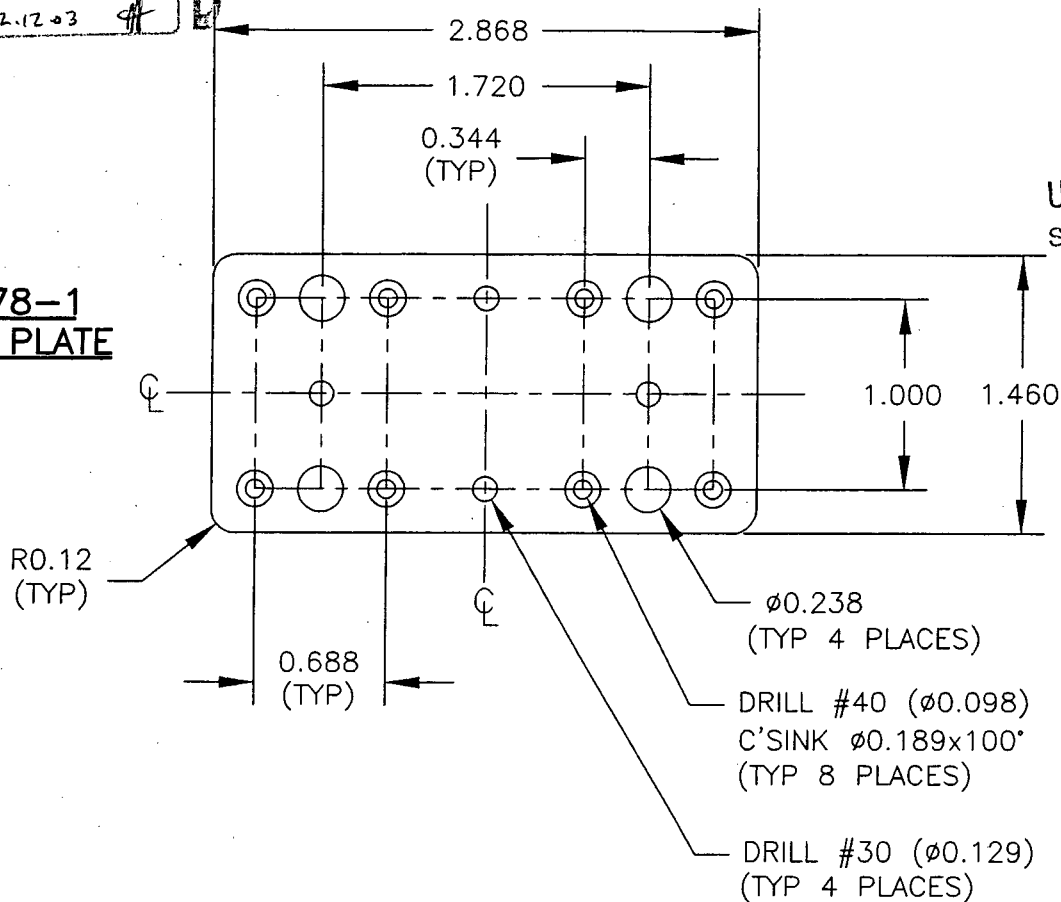


DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3178	REV. A SHEET 1 OF 1
DATE 02.12.03		TITLE NUT PLATE	SCALE 1:1
A	02.12.03	NEW ISSUE	

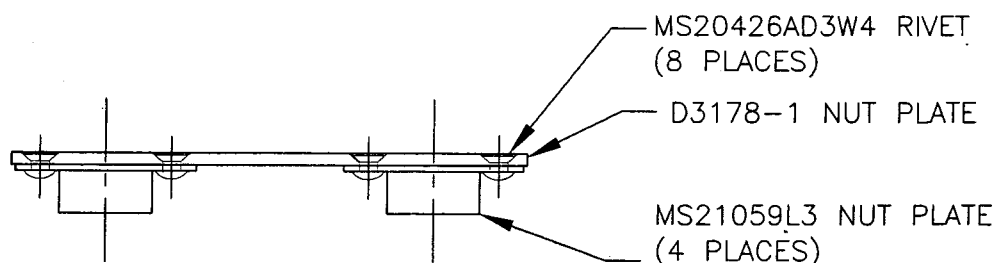
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02.12.03

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WORK ORDER  
NO. 20296

**D3178-1  
NUT PLATE**



**D3178-041  
NUT PLATE**



**NOTES, D3178-1 NUT PLATE:**

- 1) PART IS SYMMETRIC ABOUT CENTERLINES
- 2) MATERIAL: 5052-H32/H34 SHEET 0.063 THICK (QQ-A-250/8)  
(REF DART SPEC. M5052H32S.063)
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jan 26, 2004  
10:40 am

Work Order No : 0020296  
Project Name : \*K10017  
Project For : WK406  
Work Order Type : Main  
Main WO Number :  
House Part Number : \*K10017  
Description : Mtg Lug/Nut Plate Kit  
Manufactured : Yes  
Amount Req'd : 6  
Amount Done : 0  
Start Date : 01-26-04  
Est Finish Date : 02-04-04  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Margin : 0.000%  
Actual Margin : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00







